

Date: Friday, 9/21/2007 1:17:04 PM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	WEARPAD
Job Number	34805			
Estimate Number	12785			
P.O. Number			Part Number	D356411
This Issue	9/21/2007	S.O. No. :	Drawing Number	D3564 REV D
Prsht Rev.	NC		Project Number	N/A
First Issue	9/21/2007	Type	Drawing Revision	D
Previous Run	34352		Material	
Written By	<u>JL</u>		Due Date	10/5/2007
Checked & Approved By	<u>9809.09.24</u>		Qty:	<u>50</u> Um: Each
Comment	Est Rev:A New Issue 07-03-08 ec Est Rev:B As per Rev C 07-07-09 JLM Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet $x 24 = 22.0848$
Comment: Qty.: 0.9177 sf(s)/Unit Total : 27.5310 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: <u>10530</u> <u>HB</u> <u>07-10-15</u> <u>105824 X 17 = 15.6009</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3564 *****(D3564-1F)**** Dwg Rev: <u>B</u> <u>HB 07-10-15</u> Prog Rev: <u>B</u>		
2-Deburr if necessary <u>HB 07-10-15</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <u>HB 07-10-15</u>
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK <u>En 07/10/16 (x 4)</u> <i>counter</i>
Comment: SECOND CHECK		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT 8179 and DT 8155		
<u>8179</u> <u>8155</u> <u>8155</u> <u>07/10/17</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action - Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

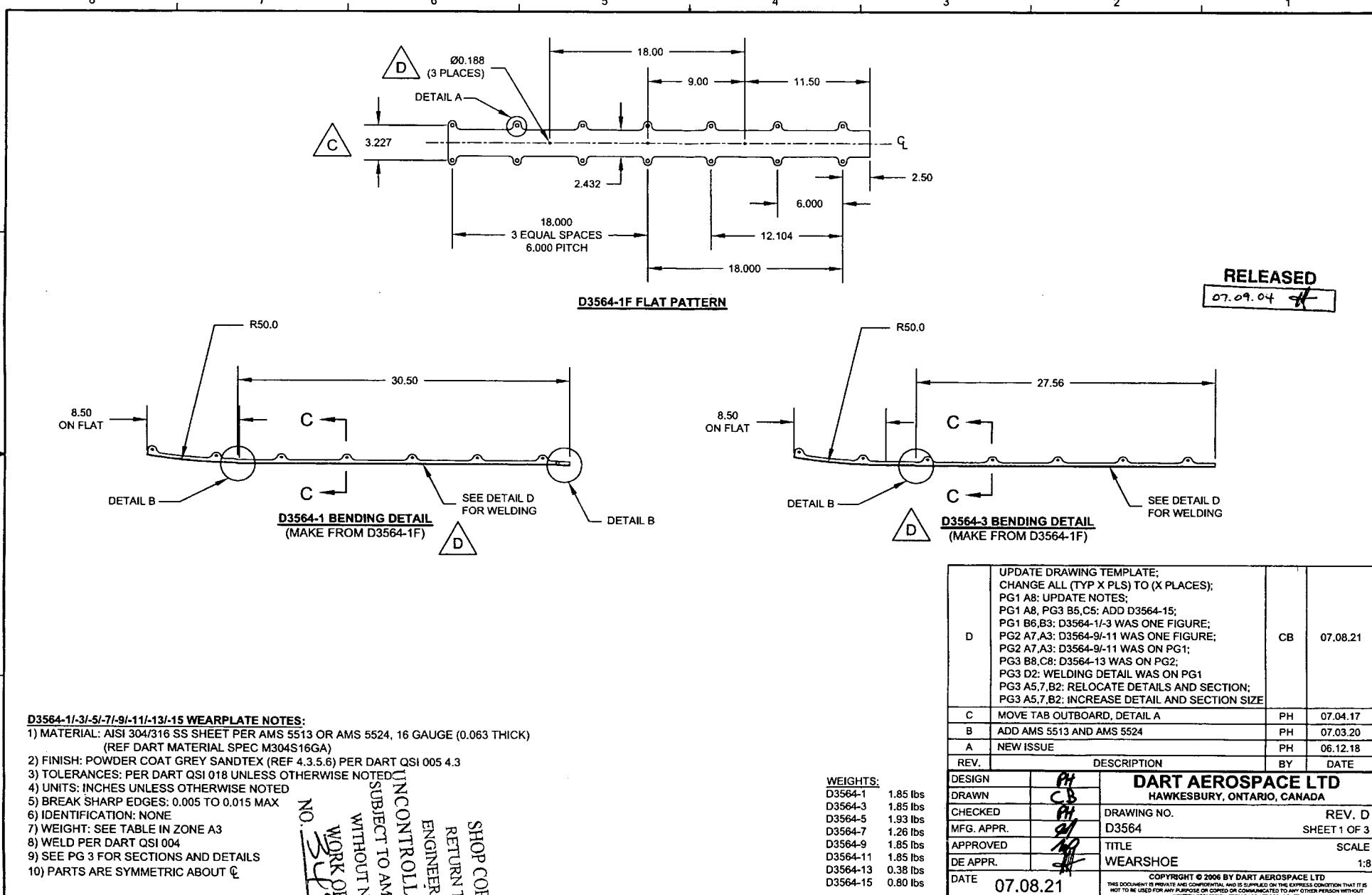
Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: WEARPAD
Job Number: 34805		Part Number: D356411
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP Ensure joggle as per dwg D3429		<i>E d/l/07 X91</i> <i>center</i>
7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1 
Comment: LARGE FABRICATION RESOURCE 1		
Qty	Description	Batch
A/R	2059B Hardcoat	<i>M06036</i>
Weld hardcoat as per Dwg D3437		<i>FL 07 11 02 (41)</i>
8.0	QC9	VISUAL WELDING INSPECTION 
Comment: VISUAL WELDING INSPECTION		<i>P 07-11-05 (42)</i>
9.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		<i>P 07-11-05 (42)</i>
10.0	POWDER COATING	POWDER COATING 
Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3		<i>M 105642.</i> <i>FL 07/11/06 (42)</i>
11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		<i>M-1 07/11/06</i> <i>(42X)</i>
12.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: F-P 15		<i>M-1 07/11/06</i> <i>(42X)</i>
13.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		<i>07.11.07 off</i>
Job Completion		 <i>6 57-11-07</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



REV.	DESCRIPTION	BY	DATE
D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5; ADD D3564-15; PG1 B6,B3; D3564-1/3 WAS ONE FIGURE; PG2 A7,A3; D3564-9-11 WAS ONE FIGURE; PG2 A7,A3; D3564-9/11 WAS ON PG1; PG3 B8,C8; D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
	DESIGN	PH	DART AEROSPACE LTD
	DRAWN	CB	HAWKESBURY, ONTARIO, CANADA
	CHECKED	PH	DRAWING NO. D3564
	MFG. APPR.	SI	REV. D
	APPROVED	SI	SHEET 1 OF 3
	DE APPR.	SI	TITLE WEARSHOE
	DATE	07.08.21	SCALE 1:8

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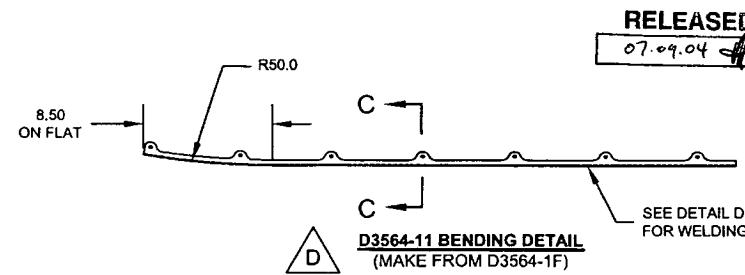
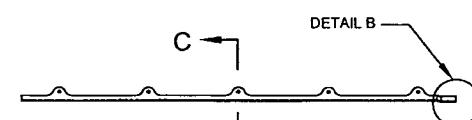
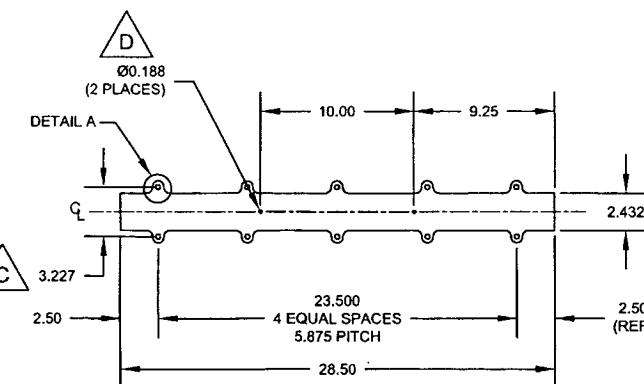
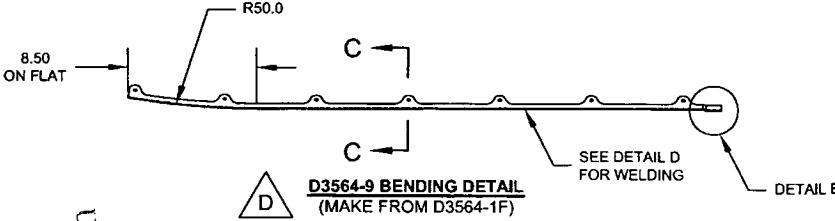
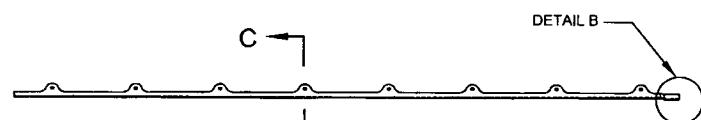
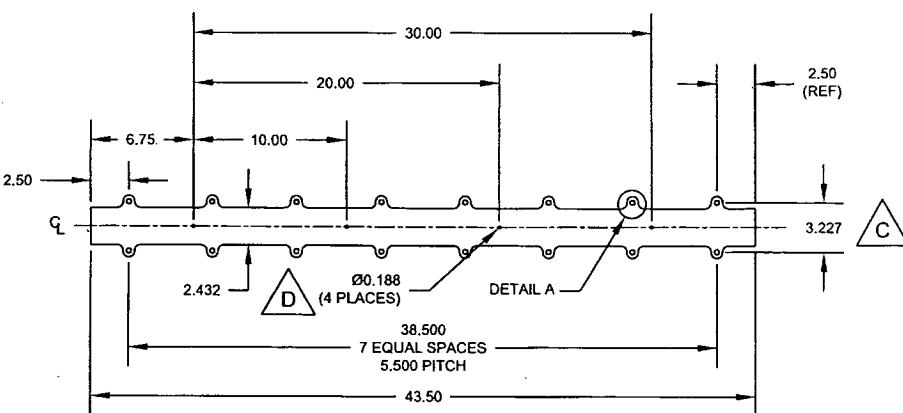
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**RELEASED**

07.09.04

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 330805

DESIGN	P	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	C	
CHECKED	P	
MFG. APPR.	S	
APPROVED	R	
DE APPR.	S	
DATE	07.08.21	REV. D DRAWING NO. D3564 SHEET 2 OF 3 TITLE WEARSHOE SCALE 1:8

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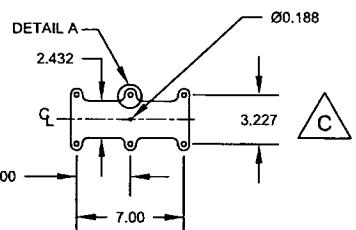
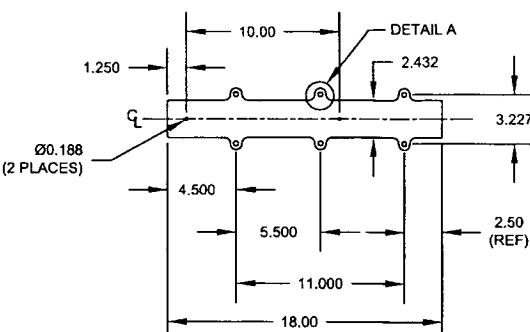
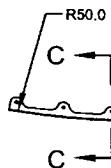
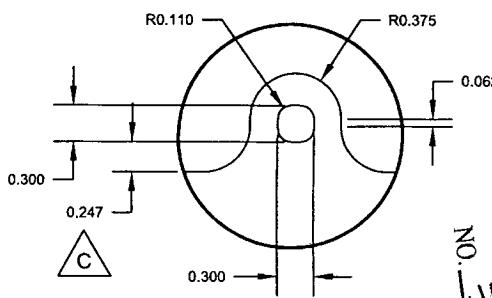
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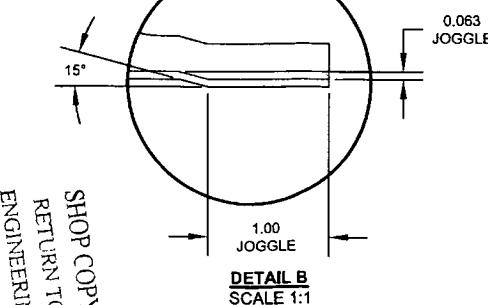
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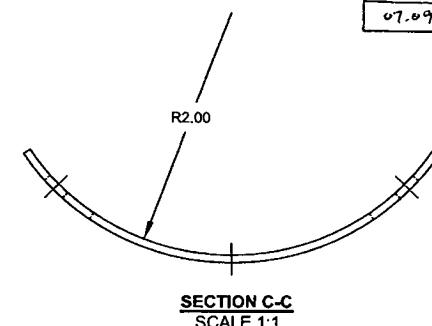
**D3564-13F FLAT PATTERN****D3564-15F FLAT PATTERN****D3564-13 BENDING DETAIL**
(MAKE D3564-13 FROM D3564-15F)**DETAIL A**
SCALE 1:1

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**DETAIL B**
SCALE 1:1

2059B HARDCOAT WELD 4.0 LONG 0.063 TO 0.125 HIGH
(11 PLACES)
WELD AFTER BENDING AS ILLUSTRATED PER DT8308

**DETAIL D**
(D3564-1/3-9-11 WELDING DETAIL)**RELEASED**07.09.04 *[Signature]***SECTION C-C**
SCALE 1:1

DESIGN	<i>PH</i>	DART AEROSPACE LTD	
DRAWN	<i>CD</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	REV. D	
MFG. APPR.	<i>SI</i>	DRAWING NO. D3564	
APPROVED	<i>NP</i>	SHEET 3 OF 3	
DE APPR.	<i>SI</i>	TITLE WEARSHOE	
DATE	07.08.21	SCALE 1:8	

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DART AEROSPACE LTD	Work Order:	34805
Description: WEAR PAD	Part Number:	D 3564-11
Inspection Dwg: D 3564 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:	IB	Audited by:	cr	Prototype Approval:	V/A
Date:	07-10-15	Date:	07/10/16	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

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